

Date: Tuesday, 7/18/2006 3:01:07 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLUG
Job Number	: 27974		
Estimate Number	: 12337		
P.O. Number	: N/A	Part Number	: D3492043
This Issue	: 7/18/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3492 REV.A UNDER REVIEW
First Issue	: N/A	Project Number	: N/A
Previous Run	: 27519	Drawing Revision	: A
	Type : MACHINED PARTS	Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 8/5/2006
Checked & Approved By	: <u>[Signature]</u> 06.07.19	Qty:	63 Um: Each
Comment	: Est Rev: A 06.03.21 New Issue JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0625	6061-T6 Round Bar .625"
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Comment: Qty.: 0.0656 f(s)/Unit Total : 3.2813 f(s)

6061-T6 Round Bar .625"

(M6061T6R625) M101421

Batch: M1004925A
[Signature] 06/08/28

63

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA632 & Dwg D3492

Dwg Rev: AFolio Rev: AA
[Signature] 06/08/28

63

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

[Signature] 06/08/28

63

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F. 06/08/29

63

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

MF 06/08/29 (63)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/11/30

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 7/18/2006 3:01:07 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 27974

Part Number: D3492043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DL 06/08/29 (63)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
(Flat End Only)

a.m 06/08/29 (63)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 10 30 (63)

9.0

NAS1611013

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Qty Part Number Description Batch

1 NAS1611-013 O-RING

101519

FC 06 10 30 (63)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Hand Finishing

2-Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube
A/R 55-O'Ring Lube Batch: 101223

FC 06 11 30 (63)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MM 06 11 30

(63)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ip + work FG

FC 06 11 30 (63)

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

AD 06/11/30 (63)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

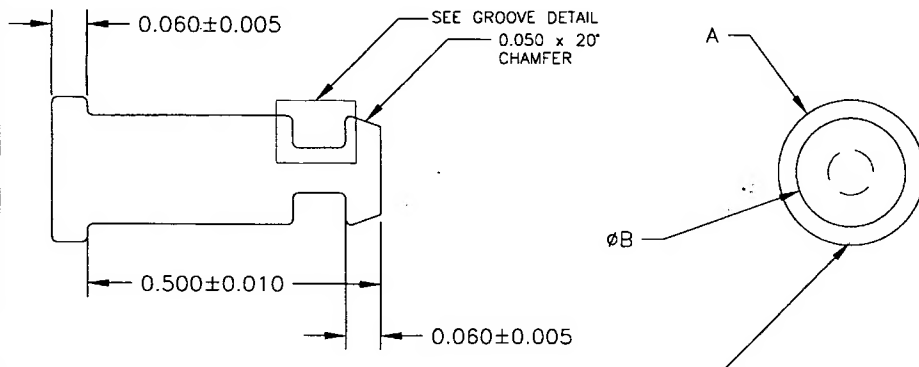
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

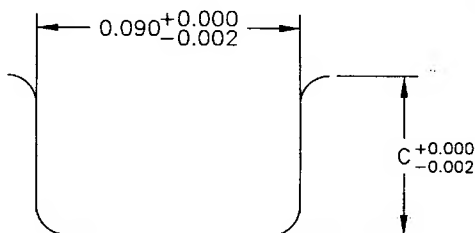
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



D3492-1/-3/-5 PLUGS IN ACCORDANCE WITH TABLE 1



GROOVE DETAIL

TABLE 1 D3492-1/-3/-5/-7 PLUG DIMENSIONS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.500	0.394	0.055	M6061T6R0.500
D3492-3	0.625	0.582	0.045	M6061T6R0.625
D3492-5	0.375	0.188	0.045	M6061T6R0.250

D3492-1/-3/-5 PLUG NOTES

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-O PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6RD.DDD)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTE
- 5) BREAK ALL SHARP CORNERS 0.010 MAX

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27974

D3492-1/-3/-5 PLUG IN ACCORDANCE WITH TABLE 2

NAS1611-003/-010/-013 O-RING IN ACCORDANCE WITH TABLE 2

D3492-041/-043/-045 PLUG ASSEMBLY

D3492-041/-043/-045 PLUG ASSEMBLY PARTS LIST
(TABLE 2)

Qty -041	Qty -043	Qty -045	Part Number	Description
X			D3492-041	PLUG ASSEMBLY
	X		D3492-043	PLUG ASSEMBLY
		X	D3492-045	PLUG ASSEMBLY
1			D3492-1	PLUG
	1		D3492-3	PLUG
		1	D3492-5	PLUG
		1	NAS1611-003	O-RING
1			NAS1611-010	O-RING
	1		NAS1611-013	O-RING

NAS1611-005

UNDER REVIEW

PH
06.07.19
06-07-19 PH
-045 PLUG NEEDS
NAS1611-005 O-RING

RELEASED
06.02.07

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DESIGN	PH	DRAWN BY	PH	
CHECKED	#	APPROVED	#	
DATE	06.01.04	DRAWING NO.	D3492	REV. A
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			PLUG	SCALE
				NTS

